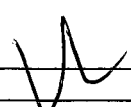
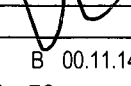













Date: Monday, 27/08/2007 3:31:27 PM
User: Linda Lacelle

Process Sheet

For Haas #2

Customer : CU-DAR001 Dart Helicopters Services Job Number : 34273 Estimate Number : 10514 P.O. Number : N/A This Issue : 27/08/2007 S.O. No. : N/A Prsht Rev. : NC First Issue : N/A Type : MACHINED PARTS Previous Run : 30819 Written By :  Checked & Approved By :  Comment : Est: B 00.11.14 Revised Finishing step to Acid etch and Alodine EC	Drawing Name : STOP Part Number : D28051 Drawing Number : D2805 REV. B Project Number : N/A Drawing Revision : B Material : N/A Due Date : 03/09/2007 Qty: 12 Um: Each	
Additional Product		
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B1500X01500	6061-T6 Bar 1.5" x 1.5"
 		
Comment: Qty.: 0.2756 f(s)/Unit Total: 3.3075 f(s) 6061-T6 Bar 1.5" x 1.5" Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11) 1.5" x 1.5" (M6061T6B1500X01500) Batch: M102723 J.L 07/08/28		
2.0	BAND SAW	BAND SAW
 		
Comment: BAND SAW Cut Bar: 3.150" Long +0.010/-0.030" J.L 07/08/28		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
 		
Comment: HAAS CNC VERTICAL MACHINING #1 1- Machine as per Folio FA104 and Dwg D2805 2- Tumble and Deburr Identify as D2805-1 J.L 07/08/28		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
 		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE J.L 07/08/28		
5.0	QC8	SECOND CHECK
 		
Comment: SECOND CHECK J.L 07/08/28		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 07/10/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 27/08/2007 3:31:27 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STOP

Job Number: 34273

Part Number: D28051

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

MS 07-08-28 (12)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



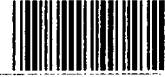
Comment: INSPECT ALODINE

CP 07/08/28 (6) 54/012 (6)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

CP 07/08/28 (6) 12

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

12 07/08/29

Job Completion



12 07-08-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

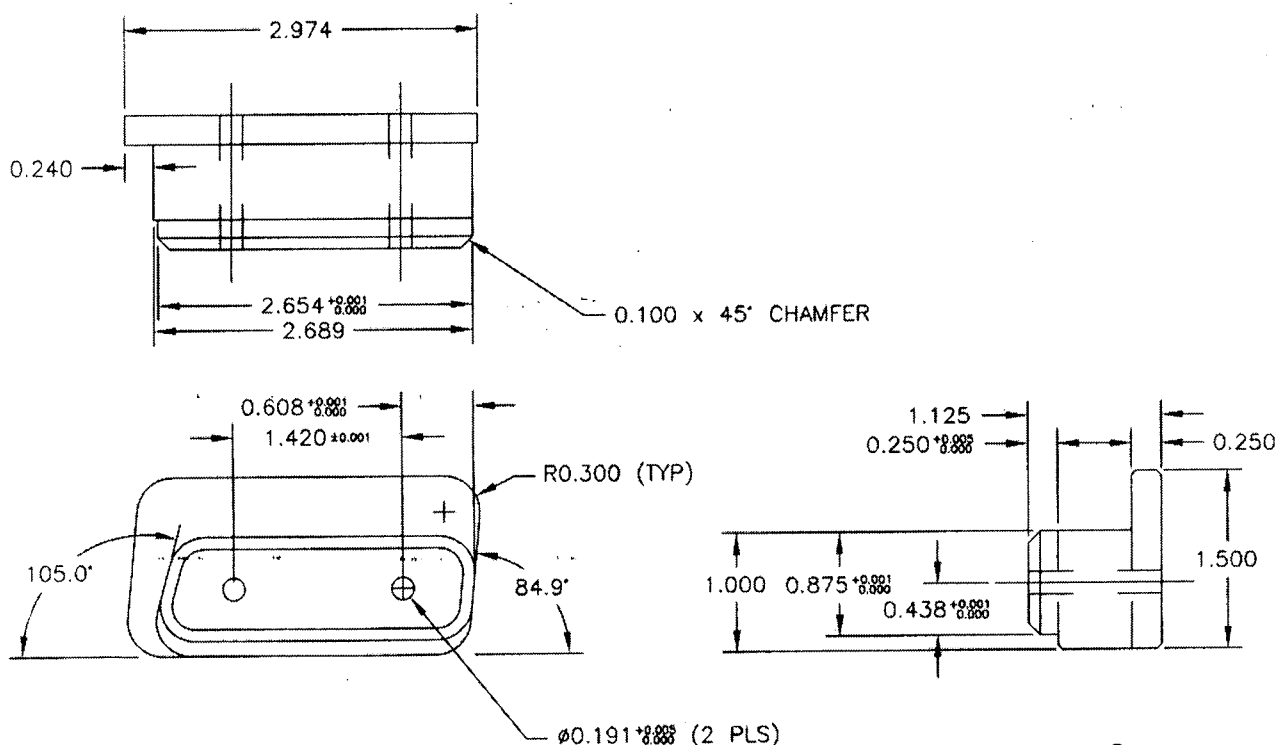
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN ✱	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED ✱	APPROVED ✱	DRAWING NO. D2805	REV. B SHEET 1 OF 2
DATE 01.03.13		TITLE STOP	SCALE 2:3
A	00.10.31	NEW ISSUE	
B	01.03.13	ADD -3/-4	

RELEASED
01.03.16



W/O 34273

D2805-1 (SHOWN)
D2805-2 (OPPOSITE)

BREAK ALL OUTSIDE EDGES 0.030 TO 0.060 UNLESS OTHERWISE NOTED.
BREAK ALL INSIDE EDGES 0.005 TO 0.015 UNLESS OTHERWISE NOTED.
MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

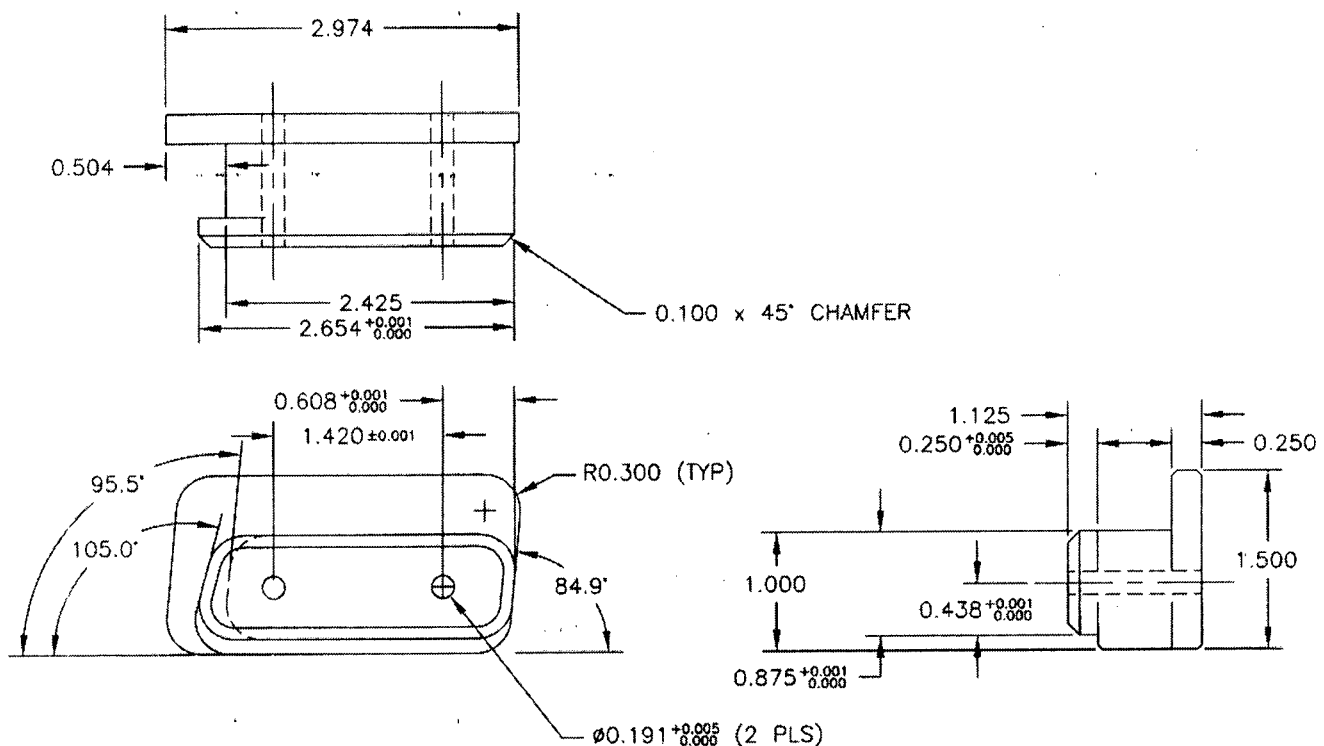
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2805	REV. B SHEET 2 OF 2
DATE 01.03.13		TITLE STOP	SCALE 2:3

RELEASED
01.03.16



D2805-3 (SHOWN)
D2805-4 (OPPOSITE)

BREAK ALL OUTSIDE EDGES 0.030 TO 0.060 UNLESS OTHERWISE NOTED.
BREAK ALL INSIDE EDGES 0.005 TO 0.015 UNLESS OTHERWISE NOTED.
MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DART AEROSPACE LTD		Work Order: 34773
Description: Stop		Part Number: D2805-1
Inspection Dwg: D2805 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.974	+/-0.010	2.975	✓			
0.240	+/-0.010	.239	✓			
0.100 chamfer	+/-0.010	.100	✓			
1.420	+/-0.001	1.420	✓			
1.125	+/-0.010	1.126	✓			
0.250	+0.005/-0.000	.250	✓			
0.250	+/-0.010	.251	✓			
1.500	+/-0.010	1.495	✓			
1.000	+/-0.010	.995	✓			
0.875	+0.001/-0.000	.876	✓			
0.438	+0.001/-0.000	.438	✓			
Ø0.191	+0.005/-0.000	.195	✓			
2.689	+/-0.010	2.690	✓			

Measured by: JL	Audited by: [Signature]	Prototype Approval:	N/A
Date: 07/08/28	Date: 07/08/28	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue	KJ/JLM	
B	07.03.21	Dimensions added	KJ/JLM	